

Work Order ID 55725

January 29, 2010 8:21:37 AM



Page 1

Item ID: D3572-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Guide

Start Date: 1/28/10

Start Qty: 40.00



Cust Item ID:

Required Date: 2/08/10

Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 10/29

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3572

Rev D

100



Bandsaw

Jeaspa Bandsaw

BAND SAW

Memo

Cut blank .500" long

0.00

0.00

DTP
10/02/02

40 0

110



HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

1- Mill as per Folio FA685 Rev: AA & Dwg D3572 Rev: D 12-Deburr
per dwg D3572

0.00

0.00

DTP 10/02/07

40 0

120



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

DTP 10/02/07

40 0

W/O:		WORK ORDER CHANGES					
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Page 2

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Reference:

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Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00

D.P 10/22/08

40

0



QC

Memo

0.00

Quality Control

140

Identify as per dwg & Stock Location: CARL

0.00



Packaging

Memo

0.00

Packaging

P. 10/2/11 (40)

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/02/11

mf

10-2-9

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Picklist Print

Page 1

January 29, 2010 8:21:41 AM

Work Order ID: 55725



Parent Item: D3572-3



Parent Item Name: Guide

Start Date: 1/28/10

Required Date: 2/08/10

Comments: IPP Rev:A New Issue 07-02-07 JLM
IPP rev B rev.B dwg EC

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B0.750X01.50 0		Purchased	No				f	11.6350	1.6008			



6061-T6 Bar .750 X 1.50

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

110167

11.63499949

11.6349995

1.6008 DJT 10/02/02

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DART AEROSPACE LTD		Work Order:	35725
Description: Guide		Part Number:	D3572-3
Inspection Dwg: D3572	Rev: D	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.19	+/-0.030	0.19	✓			
0.188	+/-0.010	0.189	✓			
R0.13	+/-0.030	0.13	✓			
1.47	+/-0.030	1.47	✓			
0.38	+/-0.030	0.38	✓			
0.220	+/-0.010	0.220	✓			
0.03 chamfer	+/-0.030	0.03	✓			
R0.06	+/-0.030	0.06	✓			
Grain Direction	N/A	N/A	✓			

Measured by:	<i>[Signature]</i>	Audited by:	<i>[Signature]</i>	Prototype Approval:	N/A
Date:	10/02/07	Date:	10/02/08	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.01	New Issue	KJ/JLM	
B	08.04.15	Dimensions updated per Dwg Rev. C	KJ/DD	
C	09.05.15	Dwg Rev updated	KJ <i>[Signature]</i>	<i>[Signature]</i>

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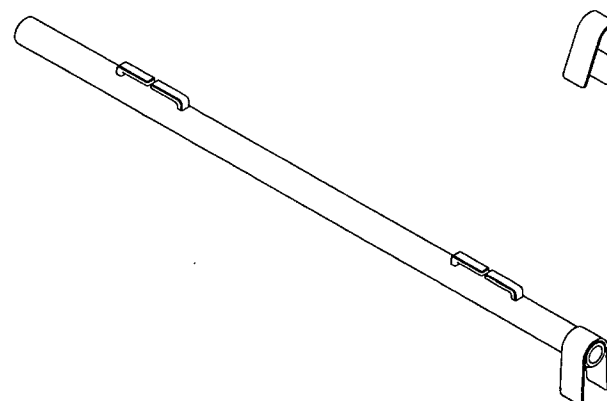
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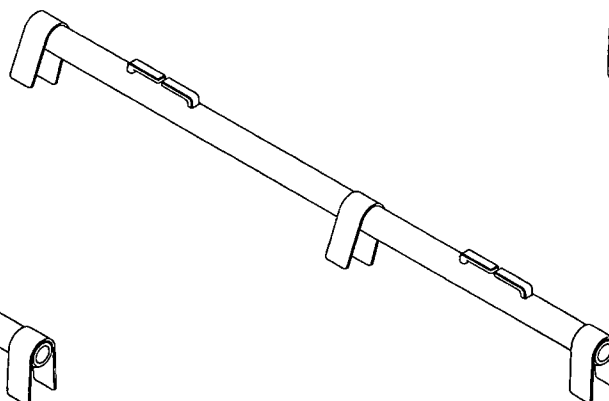
ITEM No.	QTY -041	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
1	X			D3572-041	GUIDE ASSEMBLY
2		X		D3572-043	GUIDE ASSEMBLY (UH-1)
3			X	D3572-044	GUIDE ASSEMBLY (UH-1) (OPP)
11	1	1	1	D3572-1	TUBE
12	4	4	4	D3572-3	GUIDE
13	1	3	3	D3572-5	BRACKET
14	-	-	-	D3572-7	DELETED AT REV C

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

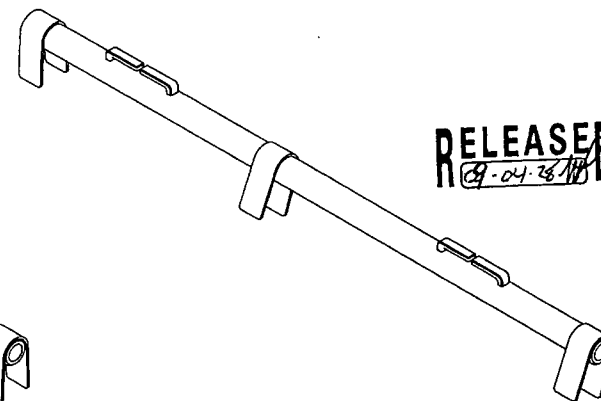
NO. 35725
BJ 10-1-29



D3572-041 GUIDE ASSEMBLY



D3572-043 GUIDE ASSEMBLY (UH-1)



D3572-044 GUIDE ASSEMBLY (UH-1)

RELEASED
09-04-28

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3572-XXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -041: 1.34 lbs
-043/-044: 1.42 lbs
- 8) WELDING: PER DART QSI 004

D	REDRAWN IN "B" SIZE FORMAT TO CURRENT STANDARDS. ADD -043, -044 FOR UH-1. SEE PAR 09-017.	AJS	09.04.17
C	REMOVE D3572-7	LE	07.06.01
B	FOR D3573-3 0.03 CHMF WAS 0.06; ADD TYP TO FILLET	LE	07.04.20
A	NEW ISSUE	LE	07.03.29
REV.	DESCRIPTION	BY	DATE
DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<u>LE</u>	DRAWING NO.	REV. D
MFG. APPR.	<u>LE</u>	D3572	SHEET 1 OF 4
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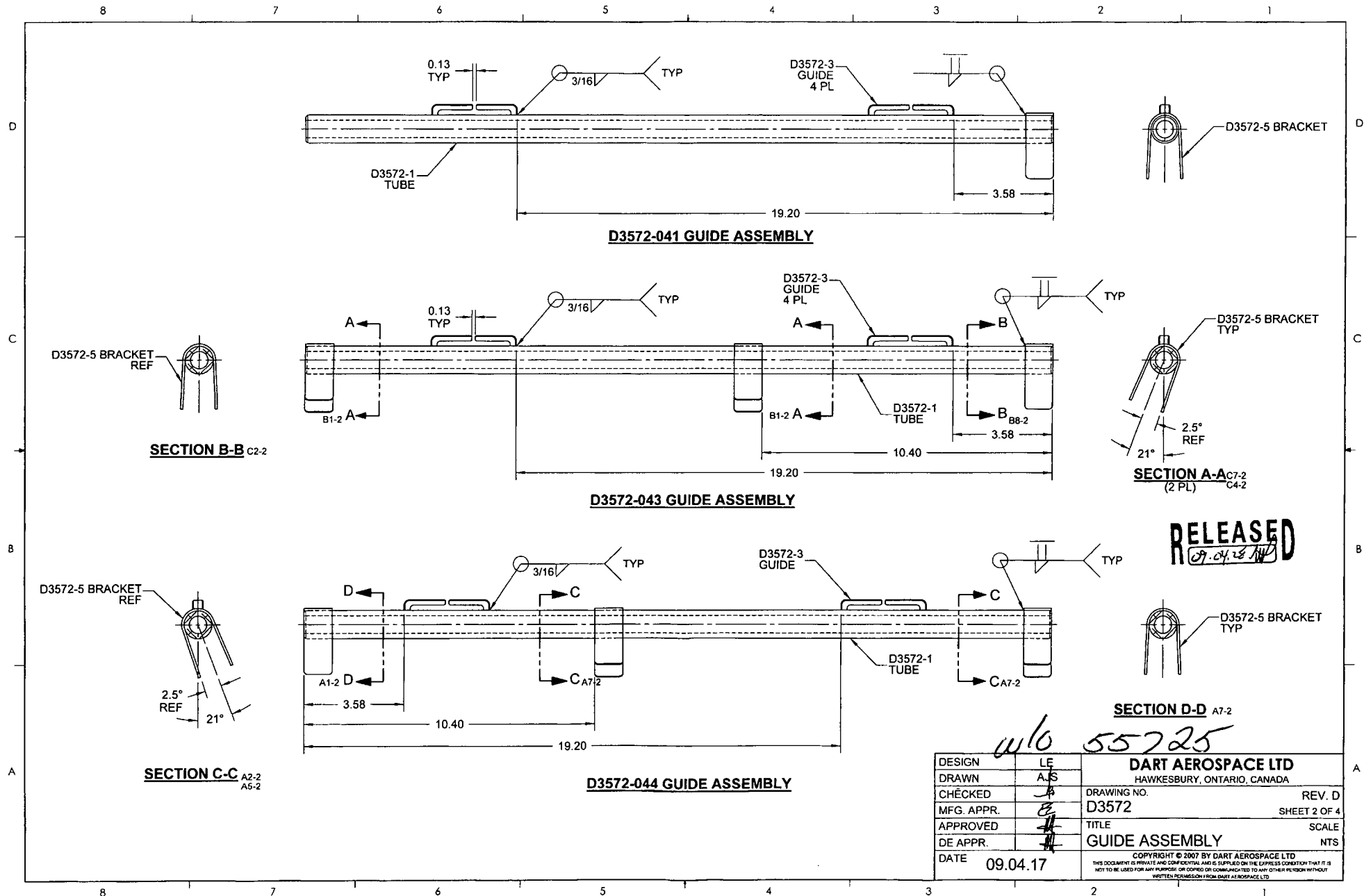
W/O:		WORK ORDER CHANGES					
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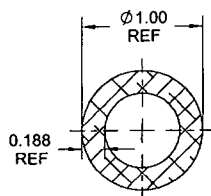
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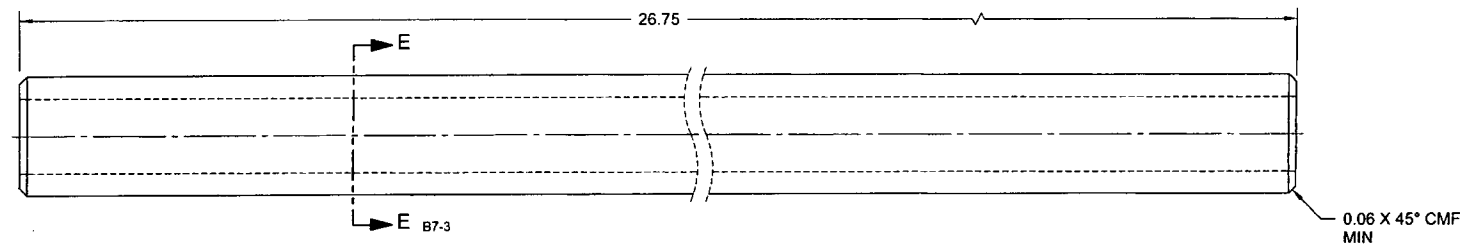
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SECTION E-E C5-3



D3572-1 TUBE

- D3572-1 NOTES:**
- 1) MATERIAL: 6061-T6 (T62) ALUMINUM TUBE 1.00 OD X 0.188 WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR AMS-QQ-A-225/8
REF DART SPEC M6061T61.000W.188
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.25 lbs

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09/04/17

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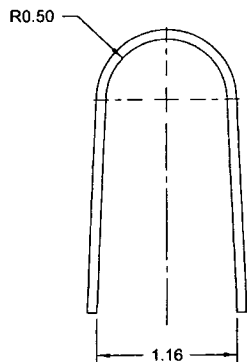
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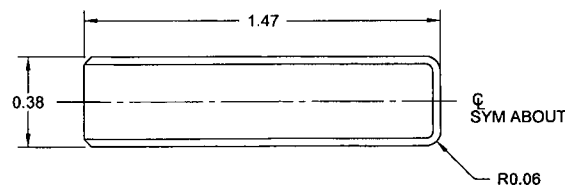
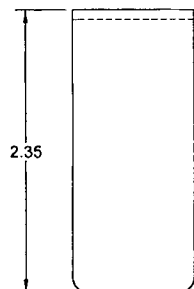
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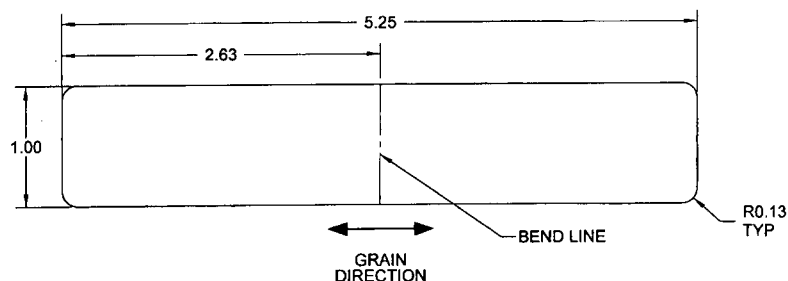
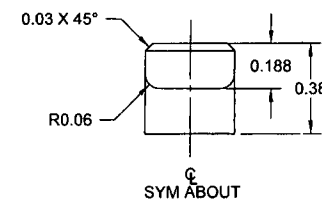
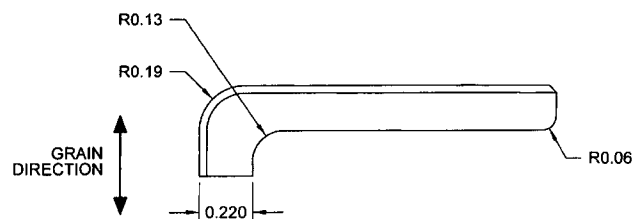
8 7 6 5 4 3 2 1



D3572-5 BRACKET
(MAKE FROM D3572-5F)



D3572-3 GUIDE



D3572-5F FLAT PATTERN

D3572-3 NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T651/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
AMS-QQ-A-200/8 (OR AMS4160)
REF DART SPEC M6061T6B
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

D3572-5 NOTES:

- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M60601T6S.080
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.04 lbs

RELEASED
9/10/13

W/O 55725

DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ANS		
CHECKED		DRAWING NO.	REV. D
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